

Date: Tuesday, 16/06/2009 11:26:59 AM  
 User: Melanie Fauteux

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	BUSHING
<b>Job Number</b> :	48613		
<b>Estimate Number</b> :	10308		
<b>P.O. Number</b> :		<b>Part Number</b> :	D26173
<b>This Issue</b> :	16/06/2009	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2617 REV D2
<b>First Issue</b> :	//	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	46606	<b>Drawing Revision</b> :	D2
	<b>Type</b> :	<b>Material</b> :	
	MACHINED PARTS	<b>Due Date</b> :	16/06/2009
<b>Written By</b> :		<b>Qty:</b>	10
<b>Checked &amp; Approved By</b> :	<i>MF 09-06-16</i>	<b>Um:</b>	Each
<b>Comment</b> :	Est G 04.07.14 Reformat; added step 5 KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T0375W058	6061-T6 RD Tube .375 x.058W
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**Comment:** Qty.: 0.0765 f(s)/Unit Total : 0.7655 f(s)

6061-T6 Round Bar 1.5"

Material : 6061-T6 (QQ-A-225/8 or QQ-A-200/8 or WW-T-700/6)

Ø0.375" tubing x 0.058" wall

(M6061T6T0.375W.058) Batch: *M110485*

*mf 09/06/16*

(10)

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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**Comment:** HARDINGE

Turn as per Folio FA437 and Dwg D2617

*mf 09/06/16*

(10)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

*mf 09/06/16*

(10)

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

*213 09/06/16*

(10)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Deburr break all unmarked sharp edges 0.005 to 0.010

*mf 09/06/16*

(10)

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Drawing Name: BUSHING

Job Number: 48613

Part Number: D26173

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Acid etch and Alodine as per QSI 005 4.1

UMD 09/06/16 X10

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09-06-16 (10)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

ST. 09-06-16

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/16 JF

Job Completion



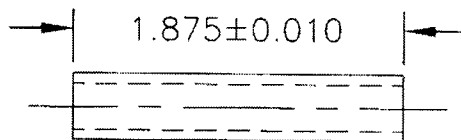
MF 09-06-16



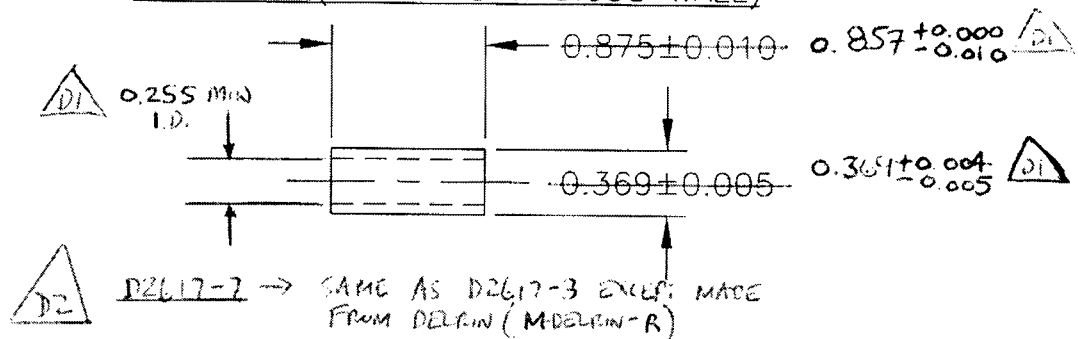


DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D2617	REV. D SHEET 1 OF 1
DATE	01.07.04		TITLE BUSHING		SCALE 1:1
D2 04.04.10 #p		ADD D2617-7		A	96.10.08 NEW ISSUE
				B	97.05.08 .875 WAS 1.125
				C	97.06.04 0.369 DIA WAS 0.375
				D	01.07.04 ADD MAT'L SPEC AND TOL./DIM. NOTE
				D1	04.07.12 CORRECT TOLERANCE (NLR 779)

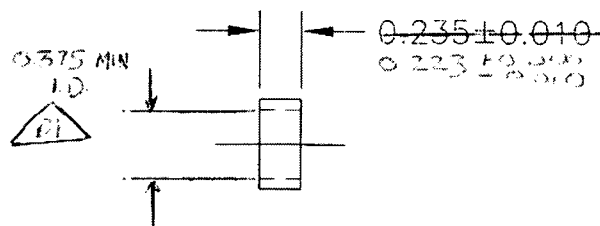
D2617-1 (0.375 OD x 0.058 WALL)



D2617-3 (0.375 OD x 0.058 WALL)



D2617-5 (0.500 OD x 0.058 WALL)



#48613

NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)  
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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